

Work Order ID 162413***162413***

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Tuesday, June 06, 2017 4:57:32 PM

Item ID: D3235-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Mounting Lug
Start Date: 6/15/2017 Start Qty: 50.00 ***50*** Cust Item ID:
Required Date: 6/23/2017 Req'd Qty: 50.00 ***50*** Customer:
Reference:

Approvals: Process Plan: DAS 21 9-89 Date: JUN 12 2017 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3235	Rev A								

110	Outsource process - Machining	0.00							
110	HAAS CNC VERTICAL MACHINING #1								
Outsource5	Memo	12,000.00							
Outsource process - Machining	Issue P/O to Metec : <u>36680</u>								
	Machine as per dwg								
	C of C is required								

120	Receive & Inspect for Damage & Mat'l Certs	0.00							
120									
Packaging	Memo	1.00							
Packaging	Ensure C of C is attach								

130	QC6- All purchased or subcontracted products	0.00							
130									
QC	Memo	0.00							
Quality Control									

DAS
38
9-89
JUN 27 2017

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Work Order ID 162413***162413***

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Item ID: D3235-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Mounting Lug

Start Date: 6/15/2017 Start Qty: 50.00

50

Cust Item ID:

Required Date: 6/23/2017 Req'd Qty: 50.00

50

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo <i>N/A</i>	0.00 0.02 <i>9-88</i>							
150 *150* QC Quality Control	QC3- Inspect Part Finish Memo <i>N/A</i>	0.00 0.50 <i>9-88</i>							
160 *160* Powdercoat Powder Coating	White Gloss(Ref 4.3.5.1) per QSI005 4.3-Alum Memo START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____ <i>N/A</i>	0.00 0.44 <i>9-88</i>							

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
		OTHER : ☐							

Work Order ID 162413

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162413

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 *170* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.50				50			DAS 38 9-89 JUN 27 2017
180 *180* Packaging Packaging	Identify as per dwg & Stock Location: <u>S+S22</u> Memo	0.00 0.50				50			DAS 6 9-89 JUN 28 2017
190 *190* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 5.00							17/7/3 

DAS
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9-89

JUN 28 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

Monday, June 05, 2017 4:53:48 PM

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Work Order ID: 162413

162413

Parent Item: D3235-1

D3235-1

Parent Item Name: Mounting Lug

Start Date: 6/15/2017

Required Date: 6/23/2017

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP A04.04.19New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2423		Manufactured	No			110	f	304.4802	0.0683	3.594737			
D2423									**			JUN 13 2017	DAS 13 9-89

Lug Extrusion

Location

Loc Qty

Loc Code

Metec

304.4801737

115229

64

127892

83.2745647

148835

157.205609

D3235-1P

Purchased

No

110

Each

0.0000

1

50

D3235-1P

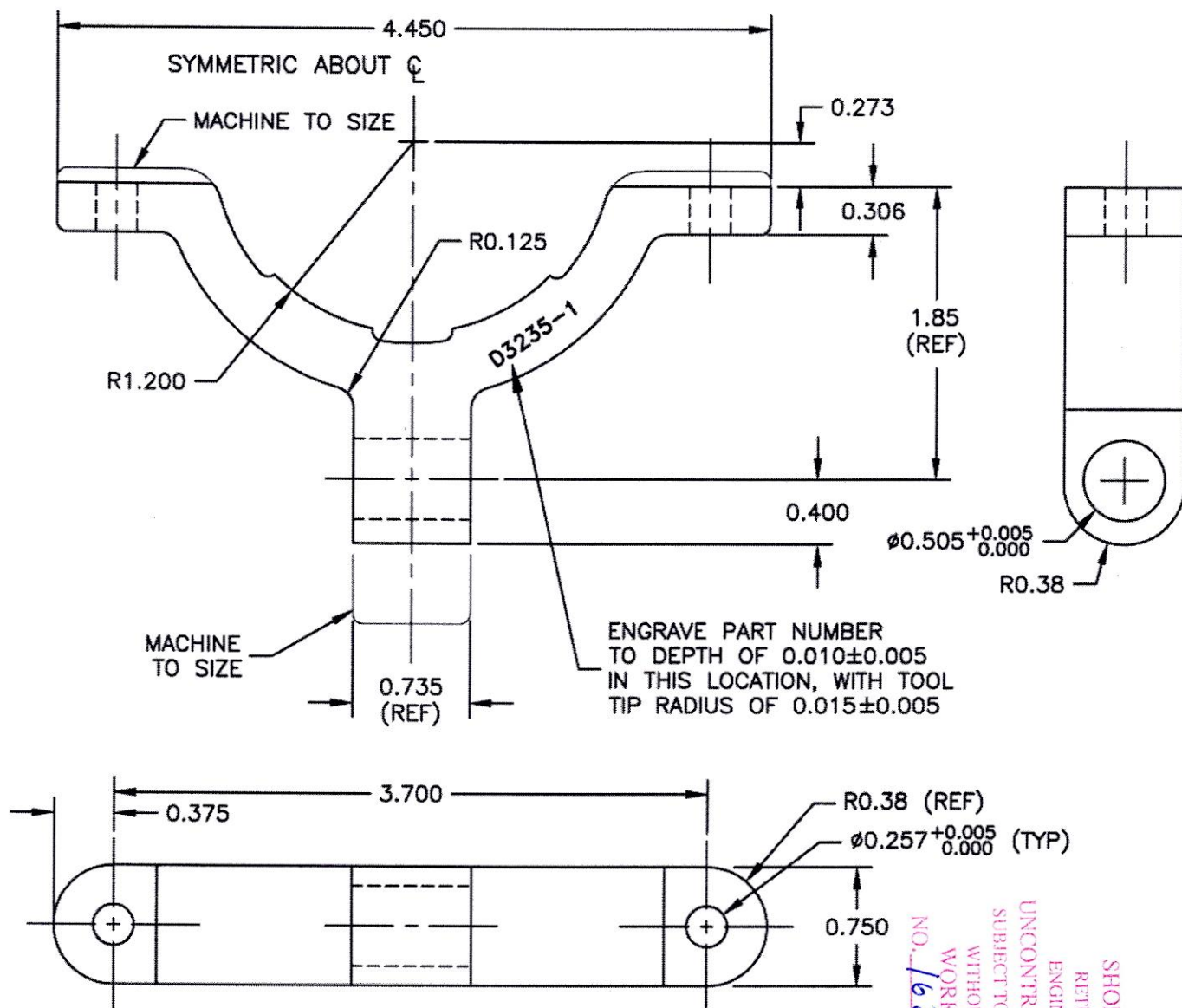
Lug

50x SP17-627



DESIGN	UP	DRAWN BY	UP	DART AEROSPACE LTD	REV. A
				HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO. D3235	SHEET 1 OF 1
DATE	04.03.02	TITLE	MOUNTING LUG	SCALE	1:1
A	04.03.02	NEW ISSUE			

RELEASED
040405



D3235-1 MOUNTING LUG

MAKE FROM EXTRUSION D2423

BREAK ALL EDGES 0.000-0.015

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 162413 M.C.S
1706-12

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO36680**

Purchase Order Date 6/13/2017

PO Print Date 6/19/2017

Page Number 1 of 4

Order From :

VC-MET003

Ship To : DART AEROSPACE LTD

METAL METAL TECHNOLOGY INC.
237 EMMY FOX DRIVE PO BOX 781
VANKLEEK HILL, ON K0B 1R0
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED

REVISED

Contact Name

Vendor Phone

613 678 3957

Ship To Contact

Ship To Phone

Ship Via:

Dart Truck

Ship Acct:

Buyer

Customer POID

Customer Tax #

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 10

CAD

Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D2230-3P	Lug	6/20/2017 Yes 6/20/2017	FN	162.00 Each	\$13.80	\$2,235.60
	AS PER DWG D2230 REV. G B162754 ALODINE AND PAINT AS PER QSI005						
	D2230-3P		7/14/2017 7/14/2017	FN	58.00 Each	\$13.80	\$800.40
Line Total:							\$3,036.00
2	D3235-1P	Lug	6/20/2017 Yes 6/20/2017	FN	50.00 Each	\$15.00	\$750.00
	AS PER DWG D1235 REV. A B162413 ALODINE AND PAINT AS PER QSI005						
Line Total:							\$750.00

Note:

6/19/2017

SP17-6-26

DAS
38
9-89



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 21746
Date: Jun 20, 2017
Page: 1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 36680	Sold By: Walz, Christian D.
Shipped By: your truck	Ship Date: Jun 20, 2017

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2230-3 Mounting Lug alodined and painted as per QSI005 162 stock / 58 ETA July 12, 2017	Each	220	162 ✓	58
D3235-1 Mounting Lug alodined and painted as per QSI005	Each	50	50 ✓	
D3235-1 Mounting Lug alodined and painted as per QSI005	Each	100	100 ✓	
D3394-3 Lug alodined and painted as per QSI005	Each	20	20 ✓	
D3910-1 Crosstube Lug alodined and painted as per QSI005	Each	20	35 ✓	
D3910-3 Crosstube Lug alodined and painted as per QSI005	Each	20	30	
D3910-5 Crosstube Lug alodined and painted as per QSI005	Each	20	20 ✓	
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.				
Received by <u>SPT 7-6-27</u>		Thank you for your order!		



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

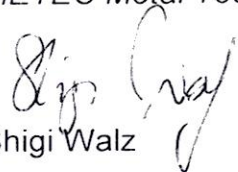
same

Quantity	Part Number	Part Name	Material Batch #	Paint Batch #	P.O. Number
162	D2230-3	Mounting Lug	148835	21012	36680
50	D3235-1	Mounting Lug	148835	21003	36680
100	D3235-1	Mounting Lug	148835	21003	36680
20	D3394-3	Lug	127892	20100	36680
35	D3910-1	Crosstube Lug	148835	21003	36680
30	D3910-3	Crosstube Lug	148835	21012	36680
20	D3910-5	Crosstube Lug	148835	20715	36680

MATERIAL: supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi Walz

Vankleek Hill, June 20, 2017